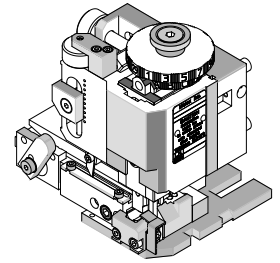


**Order Number
63902-5800**



Application Tooling Specification



FEATURES

- Quick punch removal with the push of a button for fast and easy tooling change
- Applicator designed to industry-standard mounting and shut height 135.80mm (5.346")
- Quick setup time; plus, the crimp height, track and feed adjustments can be set without removing the applicator from the press
- Fine adjustment allows users to achieve target with little effort by adjusting in increments of 0.015mm (.0006") for conductor crimp height and 0.063mm (.0025") for insulation height
- Independent adjustment rings allow users to quickly adjust the conductor or insulation crimp height without affecting each other
- This tool is IPC/WHMA-A-620 Class 2 Compliant, as indicated below
- Directly adapts to most automatic wire processing machines

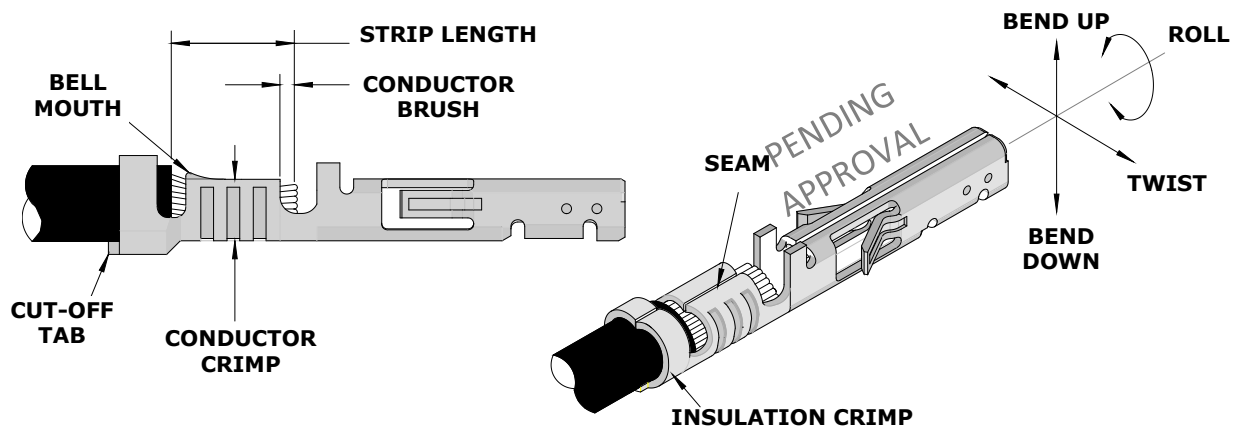
SCOPE

Products: Micro-Fit 3.0 and Micro-Fit Plus Male and Female Crimp Terminals, 0.75mm² and 18 AWG (UL1061) wires.

Terminal Series No.	Terminal Order No.	Wire Size		Insulation Diameter				Strip Length	
				IPC/WHMA-A-620 (1)		Terminal (2)			
		AWG	mm ²	mm	In.	mm	In.	mm	In.
45807	45807-0003	18	—	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
43030	43030-0038	18	—	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
	43030-0039	—	0.75	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
	43030-0040	—	0.75	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
43031	43031-0021	18	—	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
	43031-0022	—	0.75	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
	43031-0023	—	0.75	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
203951	203951-0001	18	—	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115
206460	206460-0031	18	—	1.40-1.85	.055-.073	0.90-1.85	.035-.073	2.54-2.92	.100-.115

(1) To achieve optimum IPC/WHMA-A-620 insulation crimps, use this insulation OD range.
 (2) Overall insulation OD specification for terminal.

DEFINITION OF TERMS



CRIMP SPECIFICATION

Terminal Series No.	Bell Mouth		Cut-Off Tab Maximum		Conductor Brush	
	mm	In.	mm	In.	mm	In.
45807	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031
43030	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031
43031	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031
203951	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031
206460	0.05-0.40	.002-.016	0.30	.012	0.20-0.80	.008-.031

Terminal Series No.	Bend Up	Bend Down	Twist	Roll	Punch Width (Ref)				Seam
	Degree	Degree			Conductor		Insulation		
			mm	In.	mm	In.			
45807	3	3	4	8	1.60	.063	1.80	.071	Seam shall not be open and no wire allowed out of the crimping area
43030	3	3	4	8	1.60	.063	1.80	.071	
43031	3	3	4	8	1.60	.063	1.80	.071	
203951	3	3	4	8	1.60	.063	1.80	.071	
206460	3	3	4	8	1.60	.063	1.80	.071	

After crimping, the conductor profile should measure the following:

Terminal Series No.	Wire Size		Conductor Crimp Height		Insulation Crimp Height		Pull Force Minimum	
	AWG	mm ²	mm	In.	mm (Ref.)	In. (Ref.)	N	Lb.
45807	18	—	1.00-1.10	.039-.043	1.90	.075	89.0	20.0
43030	18	—	1.00-1.10	.039-.043	1.90	.075	63.0	14.1
	—	0.75	0.85-0.95	.034-.038	1.95	.077	63.0	14.1
43031	18	—	1.00-1.10	.039-.043	1.90	.075	63.0	14.1
	—	0.75	0.85-0.95	.034-.038	1.95	.077	63.0	14.1
203951	18	—	1.00-1.10	.039-.043	1.90	.075	89.0	20.0
206460	18	—	1.00-1.10	.039-.043	1.90	.075	89.0	20.0

Tool Qualification Notes

1. Pull force should be measured with no influence from the insulation crimp.
2. The above specifications are guidelines to an optimum crimp.
3. Oiler (63801-7240) required to crimp terminals to improve tooling life and also to minimize the crimp extrusions. See 63800-4900 FineAdjust manual.

PENDING APPROVAL

PARTS LIST

FineAdjust Applicator 63902-5800				
Item	Order No.	Engineering No.	Description	Quantity
Perishable Tooling				
	63902-5870	63902-5870	Tool Kit (All "Y" Items)	REF
1	63444-1609	63444-1609	Conductor Punch	1 Y
2	63455-0128	63455-0128	Conductor Anvil	1 Y
3	63446-1802	63446-1802	Insulation Punch	1 Y
4	63445-1809	63445-1809	Insulation Anvil	1 Y
5	63443-0005	63443-0005	Cut-Off Plunger	1 Y
6	63443-0012	63443-0012	Front Plunger Retainer	1 Y
Other Components				
7	11-17-0022	1739-21	Compression Spring	1
8	11-18-4083	60707-8	Feed Guide	1
9	11-24-1067	4996-4	Cut-Off Plunger Spring	1
10	63443-0009	63443-0009	Front Scrap Chute	1
11	63443-0024	63443-0024	Key	1
12	63443-0090	63443-0090	Wire Stop	1
13	63443-0093	63443-0093	Shank	1
14	63443-1720	63443-1720	Height Spacer	1
15	63443-2215	63443-2215	Coarse Spacer (15.00mm)	1
16	63443-2308	63443-2308	Fine Spacer (3.40mm)	1
17	63443-2802	63443-2802	Front Plunger Striker	1
18	63443-2903	63443-2903	Wire Hold Down Plunger	1
19	63443-7137	63443-7137	Terminal Hold Down	1
20	63443-6016	63443-6016	Rear Cover	1
21	63600-1057	63600-1057	Compression Spring	1
Frame				
22	63800-4901	63800-4901	Top	1
23	63801-3281	63801-3281	Base	1
24	63801-4650	63801-4650	Track	1
Hardware				
25	—	—	M3 by 6 Long SHCS	2*
26	—	—	M3 by 6 Long FHCS	1*
27	—	—	M3 by 8 Long SHCS	1*
28	—	—	M4 by 6 Long SHCS	2*
29	—	—	M4 by 12 Long BHCS	2*
30	—	—	M4 by 50 Long SHCS	2*
31	—	—	M5 by 12 Long SHCS	1*
32	—	—	#10-32 by 3/8" Long Flat Point SSS	1*
33	—	—	#10-32 Hex Jam Nut	1*

* Available from an industrial supply company.

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ASSEMBLY DRAWING

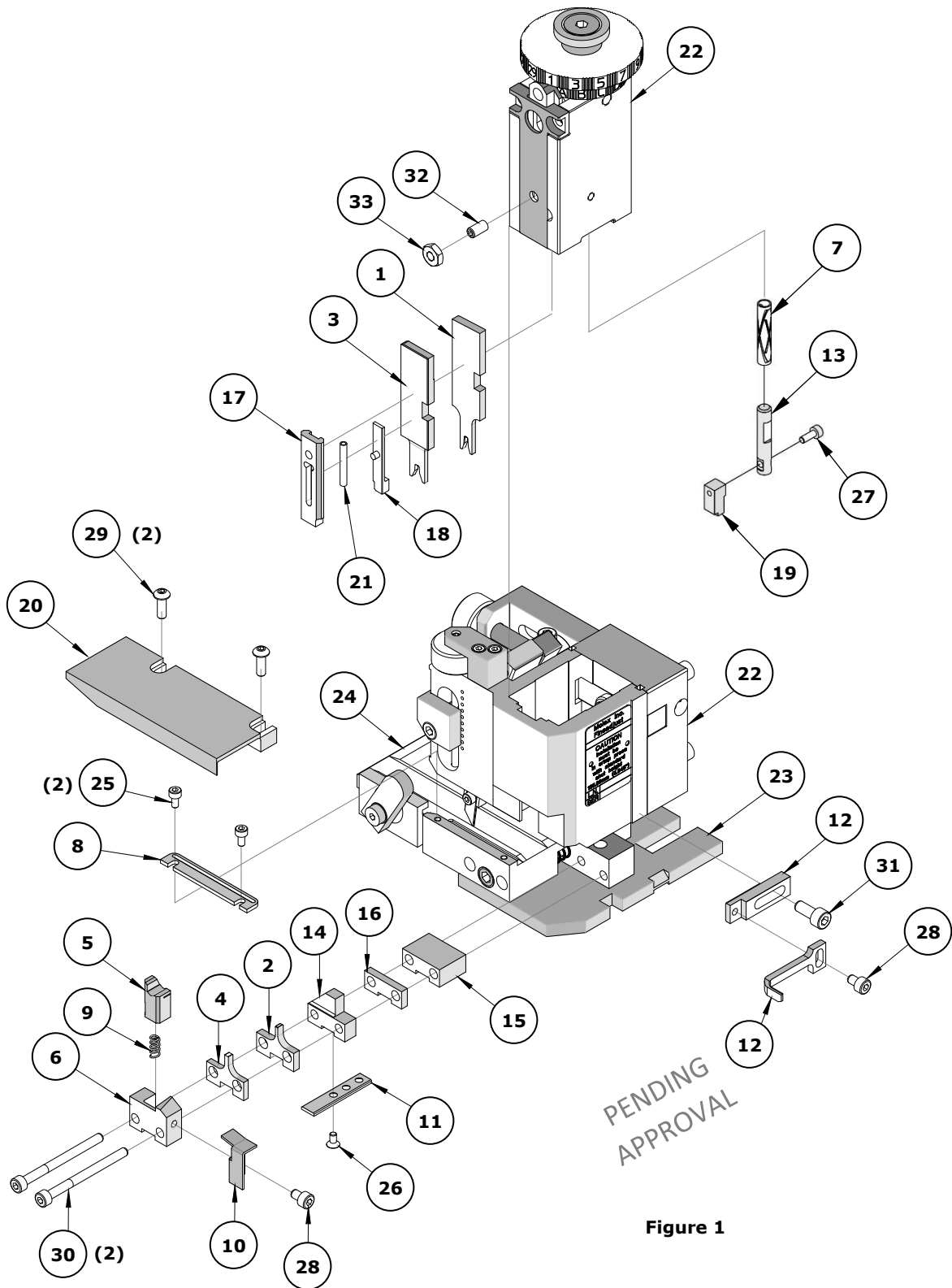


Figure 1

NOTES

1. Molex recommends that an extra perishable tooling kit be maintained at your facility.
2. Verify tooling alignment by manually cycling the press and applicator before crimping under power. Check that all screws are tight.
3. Slugs, terminals, dirt and oil should be kept clear of the work area.
4. Wear safety glasses at all times.
5. For recommended maintenance, refer to the FineAdjust manual.

CAUTION: This applicator should only be used in a press with a shut height of 135.8mm (5.346"). Tooling damage could result at a lower setting.

CAUTION: To prevent injury, never operate this applicator without the guards supplied with the press or wire-processing machine in place. Reference the press or wire processing manufacturer's instruction manual.

CAUTION: Molex crimp specifications are valid only when used with Molex terminals, applicators and tooling.

PENDING
APPROVAL

Application Tooling Support

Phone: (402) 458-TOOL (8665)
E-Mail: applicationtooling@molex.com
Website: www.molex.com/applicationtooling

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